

Work Order ID 109670

November-25-13 10:14:59 AM

109670

Page 1

Item ID: D4095-049

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearpad Assembly

Start Date: 11/25/13 Start Qty: 10.00

10
10 12*

Cust Item ID:

Required Date: 12/09/13 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-11-25 Tooling:

Date: _____

Date: _____

Run Start

NR1

QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4095	B
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100	FLOW WATER JET	0.00	12	0	Ae	13-11-26
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100	Waterjet	0.00	12	0	Ae	13-11-26
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FLOW/CNC Waterjet	Memo	0.00	12	0	Ae	13-11-26
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1-Cut as per Dwg (D4095-9)			12	0	Ae	13-11-26
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Dwg Rev: 3			12	0	Ae	13-11-26
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Prog Rev: B			12	0	Ae	13-11-26
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2-Deburr if necessary			12	0	Ae	13-11-26
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110	QC2- Inspect parts off machine FAI/FAIB	0.00	12	0	Ae	13-11-26
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110	QC	0.00	12	0	Ae	13-11-26
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Quality Control	Memo	0.00	12	0	Ae	13-11-26
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120	QC8- Inspect parts - second check	0.00	12	0	Ae	13-11-26
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120	QC	0.00	12	0	Ae	13-11-26
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Quality Control	Memo	0.00	12	0	Ae	13-11-26
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DAS
27
9-89
13-11-26

Work Order ID 109670

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109670

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Item ID: D4095-049

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearpad Assembly

Start Date: 11/25/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/09/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC	Form as per dwg NC BRAKE	0.00							13/11/27
	Memo	0.00		DAS 30 9-89					
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00		DAS 27 9-89					
	Memo	0.00	13/11/27						
150 *150* Large Fab	Weld per dwg A/R Hardcoat S.S. Batch Large Fab	0.00							13-11-27 JBL
	Memo	0.00							

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Item ID:	D4095-049	Accept	*N900040100*	Setup	Start	*NS1*	
Revision ID:					Stop	*NS2*	
Item Name:	Wearpad Assembly						
Start Date:	11/25/13	Start Qty: 10.00	*10*	Cust Item ID:			
Required Date:	12/09/13	Req'd Qty: 10.00	*10*	Customer:			
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds	0.00	<i>Sm/B</i>			<i>10</i>			
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00	<i>Sm/B</i>			<i>10</i>			
180 *180* HandFinish Hand Finishing	Memo COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG A/R ROCKGUARD BATCH: <u>125335</u>	0.00				<u>12</u>	<u>0</u>	<u>0</u>	<u>A8</u> 13-11-27

Work Order ID 109670

November-25-13 10:14:59 AM

109670

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Item ID: D4095-049

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Wearpad Assembly

Stop

NS2

Start Date: 11/25/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/09/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

DAS
05

13-11-28

200

Identify as per dwg & Stock Location: F1-001

0.00

200

Packaging

Memo

0.00

Packaging

X-12 4 M 13/11/28

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

AM 13/11/28

MR 13-11-28

Picklist Print

November-25-13 10:15:02 AM

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Work Order ID: 109670

109670
D4095-049

Parent Item: D4095-049

Parent Item Name: Wearpad Assembly

Start Date: 11/25/13

Required Date: 12/09/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev.A 11.11.07 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA	Purchased	No					sf	352.2540		8			**
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M304S16GA

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT020	352.2539998	
123136	140.2	
M126159	26.22	
<u>M126915</u>	185.834	

Ac 13.11.26

126915 → 2.4

DART AEROSPACE LTD	Work Order:	109678
Description: Wearpad	Part Number:	D4095-9
Inspection Dwg: D4095	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

DAS

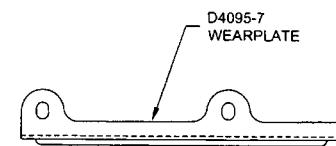
Measured by: <u>Ac</u>	Audited by: <u>27</u> <u>9-89</u>	Preliminary Approval:
Date: <u>13.11.26</u>	Date: <u>B 11 26</u>	Date:

Rev	Date	Change	Revised by	Approved
A	11.11.08	New Issue	P/O D4095-049	KJ

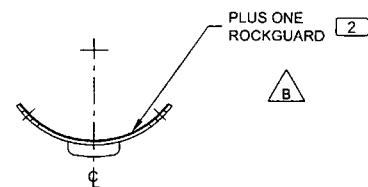
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D

D

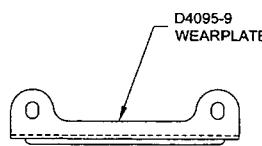


D4095-047 WEAR PAD ASSEMBLY

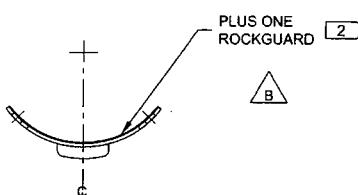


C

C



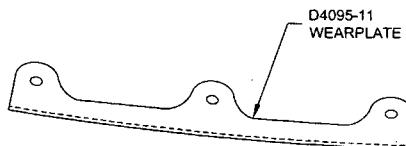
D4095-049 WEAR PAD ASSEMBLY



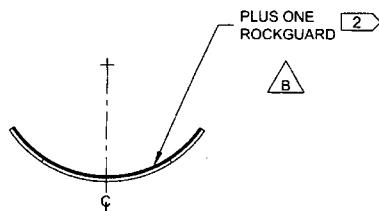
109670MCS
13-11-25

B

B



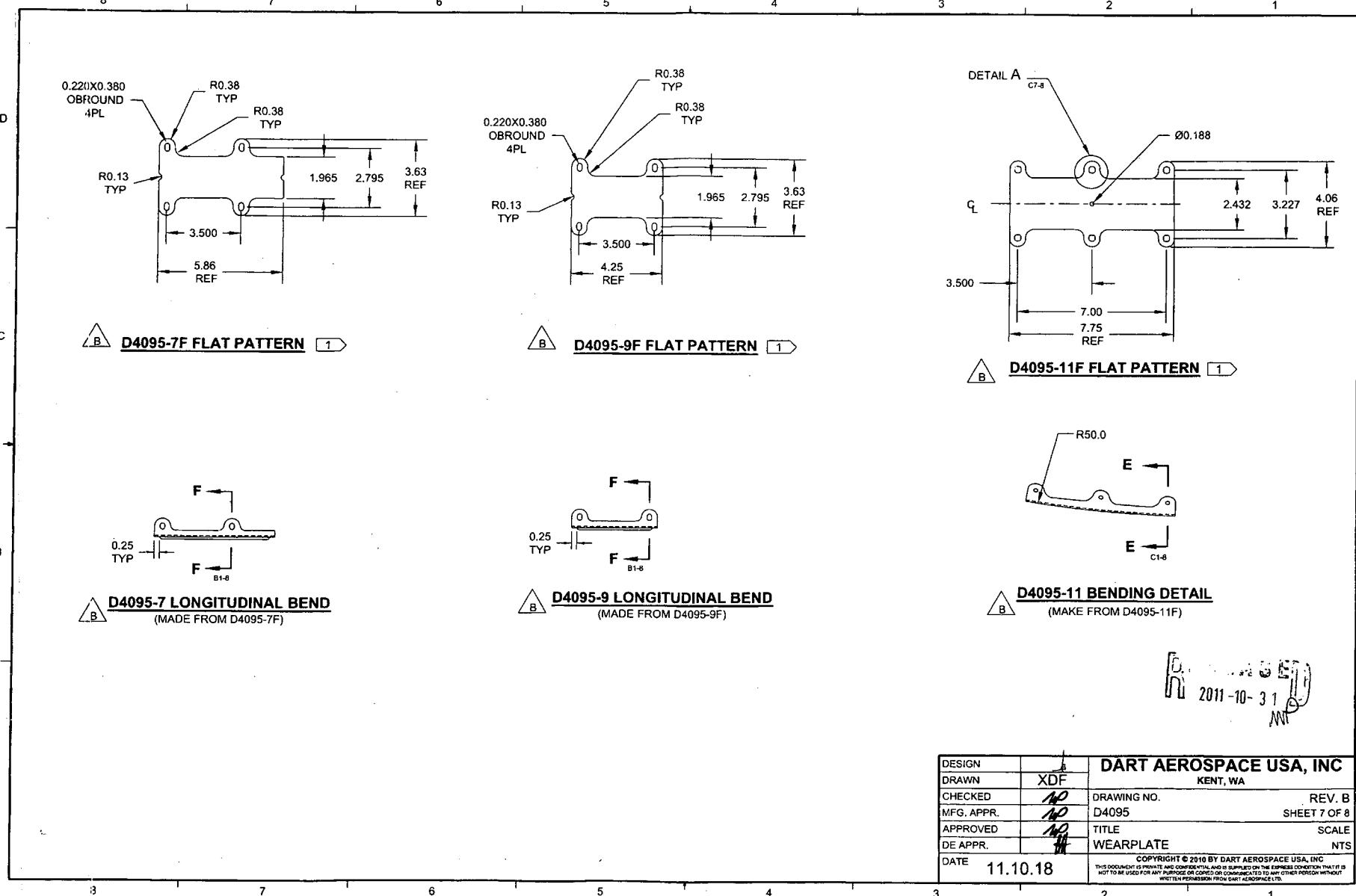
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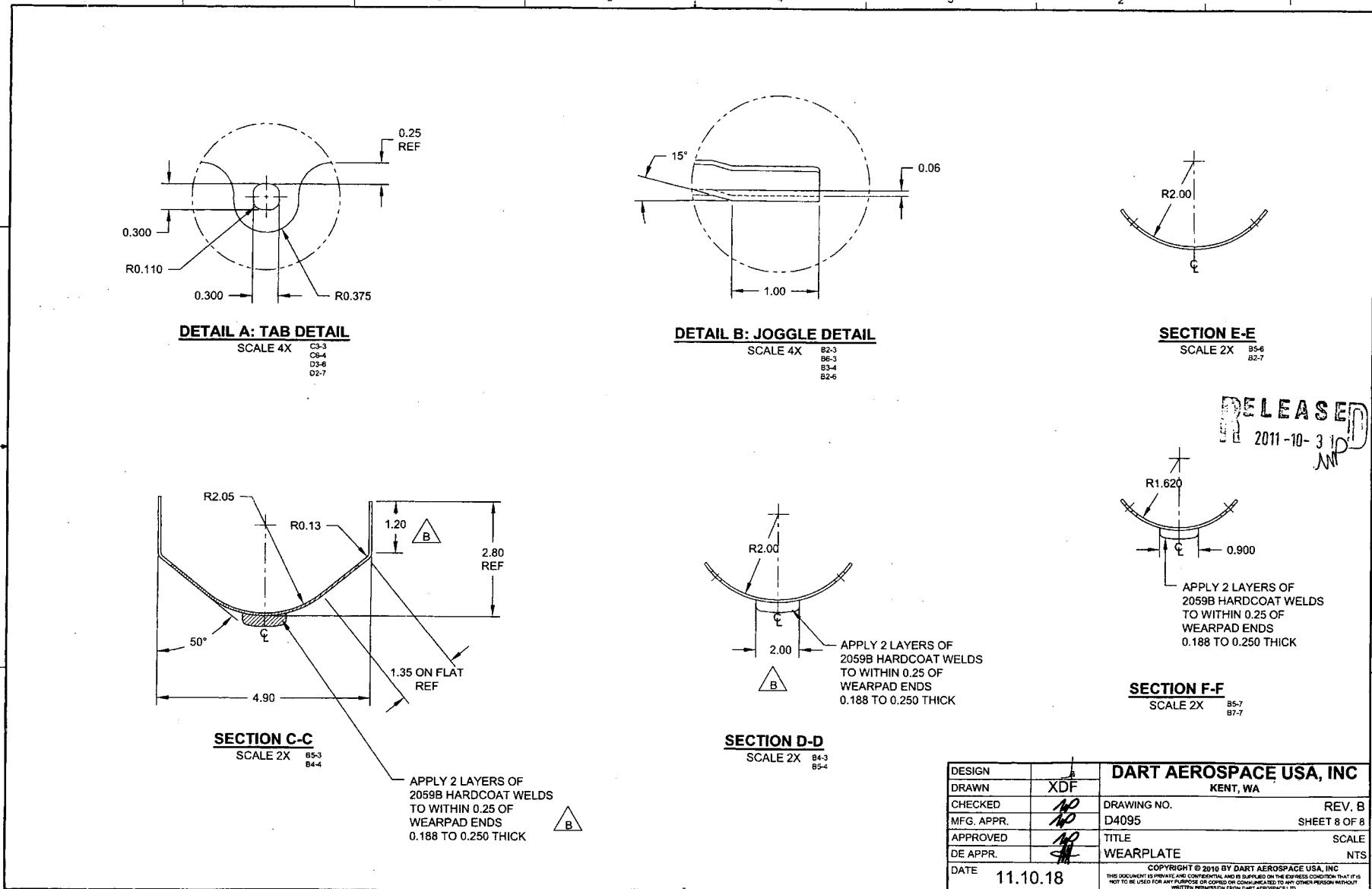


RELEASED
2011-10-31
M

8 7 6 5 4 3 2 1

DESIGN	8	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D4095	SHEET 2 OF 8
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	WEARPLATE	NTS
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DESIGN	XDF
DRAWN	XDF
CHECKED	10
MFG. APPR.	10
APPROVED	10
DE APPR.	10
DATE	11.10.18
DRAWING NO.	REV. B
D4095	SHEET 8 OF 8
TITLE	SCALE
WEARPLATE	NTS
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